

Date: Tuesday, 4/17/2007 3:56:26 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP (CASTING DETAIL)		
Job Number	: 31925		Part Number	: D25763		
Estimate Number	: 10510		Drawing Number	: D2576 REV. E1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 4/17/2007	S.O. No.	: N/A		Drawing Revision	: E1
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/5/2007 Qty: 100 Um: Each		
Previous Run	: 29486					
Written By						
Checked & Approved By						
Comment	: Est: E 02.08.19 Consolidated D2576-1 and D2576-3 KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D25761	Step (Casting Detail)
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) Pick: Qty Part# Description Batch 1 D2576-1 Step (Casting Detail) <u>31940</u>
		JL/J.F. 07/06/13 106
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS1 1- Machine as per Folio FA332 and Dwg D2576 2- Deburr
		JL/J.F. 07/06/13
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
		JL/J.F. 07/06/17
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
		JL 07.06.21
5.0	PACKAGING.1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Barclay</u>
		JL 07/06/21 106

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D0576-3 PAR #: N/A Fault Category: Pad / Machine Parts NCR: Yes No DQA: DS Date: 07/06/20
 QA: N/C Closed: HJ Date: 07.06.20

NCR: <u>31925</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/18	2.0	3 parts were under .125" by 0.003" max at the aft welding location. R.C. cap was slightly lifted during machining.	<u>DS</u> scratches	Parts acceptable, but dimensions are not in a critical spot.	JL 07/06/19	<u>DS</u> 07/06/18	<u>DS</u> 07/06/18	<u>DS</u> 07/06/18
07/06/18	2.0	3 parts scrapp. Parts pulled up to much, and have toolmarks in them, and dimensions are too thin. .098->.100.	<u>DS</u> 07/06/18	Scrap 3 parts & destroy.	JL 07/06/19	<u>DS</u> 07/06/18	<u>DS</u> 07/06/18	<u>DS</u> 07/06/18

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



103

Comment: FINAL INSPECTION/W/O RELEASE

P07/06/022

Job Completion



u 07/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31925
Description: Step	Part Number:	D2576-3
Inspection Dwg: D2576	Rev: E1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	JF	Audited by:	MS	Prototype Approval:	N/A
Date:	07/06/13	Date:	07/06/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF	TT



DR COPY ISSUED
PMS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2576
DATE		REV. E
99.09.07		SHEET 1 OF 1
		SCALE 1:4
A	96.09.18	NEW ISSUE
B	96.11.28	REMOVE POCKETS, ADD HOLE
C	98.08.18	ADD POCKETS & SLOTS FOR WELDING
D	99.08.18	CHNG. SLOT SIZE AND LOC.(TSR A1069)
E	99.09.07	CHNG. 0.50 HOLE LOC. AND ADD NOTE
E1	RF 03.04.29	7.05 WAS 6.61

RELEASED
99.09.08 DS

#00.08.28

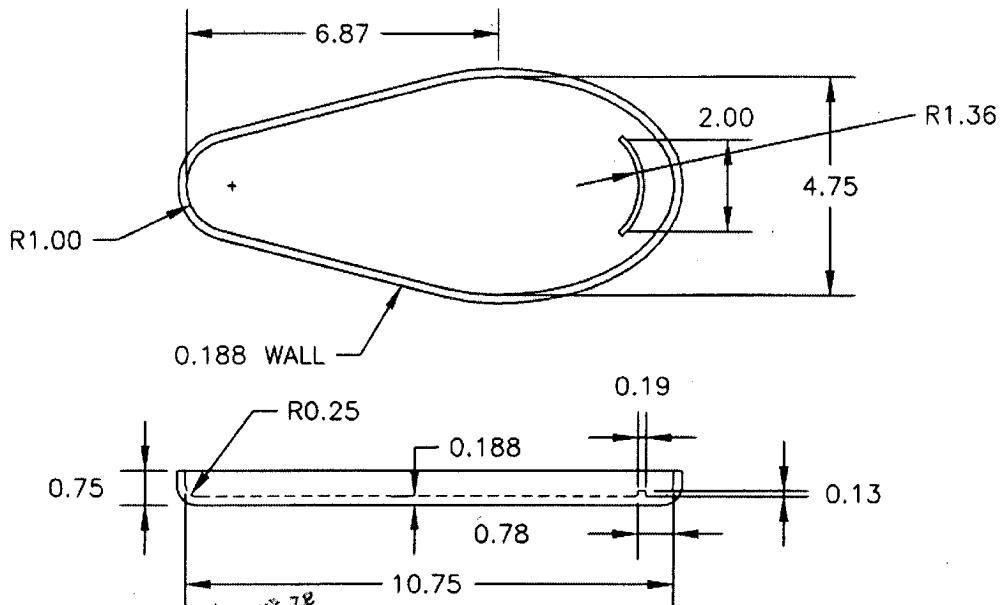
CASTING DETAIL (D2576-1) #00.08.28

MATERIAL: CAST ALUMINUM ALLOY A-535.2

BREAK SHARP EDGES 0.025 TO 0.050

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

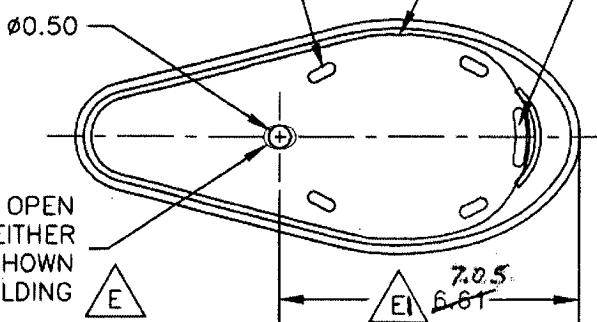


MACHINING DETAIL (D2576-3) #00.08.28

D 0.250 X 0.65 SLOT
(4 PLACES)
IN APPROX. LOCATION SHOWN

0.063 POCKET (LEAVE 0.125)

D



IT IS ACCEPTABLE TO OPEN
THIS HOLE 0.125 IN EITHER
DIRECTION AS SHOWN
FOR WELDING

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31925